

Date: Thursday, 12/03/2009 10:34:11 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 407 FWD X-TUBE
<b>Job Number</b> : 46470	
<b>Estimate Number</b> : 12348	
<b>P.O. Number</b> :	<b>Part Number</b> : D407667105
<b>This Issue</b> : 12/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D407-667-145 REVC
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : CROSSTUBES	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 46469	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 01/04/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.03.12</u>	
<b>Comment</b> : Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM	
Est Rev:G 08-05-16 chg QC6 to QC15 DD verified by:EC	
Est Rev:H 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec	
Est Rev:I 08-07-14 add (scribe inside of tube) seq.6 DD verified by:EC	
Est Rev:J 08-07-28 update as per (par 08-013) DD verified by:EC	
Est Rev K 09.01.06 ECN 08-562 EC verified by:DD	

SCRAP

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-105 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D407667105TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B-45737MB 09-03-12

①

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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MB 09-03-16



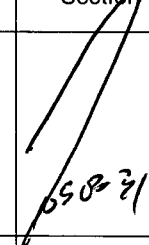

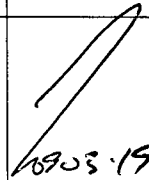
①

**Comment:** BENDING MACHINE

Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw and Folio FT016

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-667-105 PAR #: NA Fault Category: Prod / x-tube NCR: Yes No DQA: D Date: 09/04/03  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/04/03

NCR: <u>46470</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.19	4	Tube bent narrow and high. - Y axis froze during bending causing the tube to bend incorrectly. - Burnt out relays were the cause. - E.C. Machine mal function.	 09/03/31 PST 1042	Too narrow. Scrap tube CP Change relays & is incorporated into the Maintenance.	 09-03-31	 09-03-31	 09/03/31 PST 1042	 09-03-19

NOTE: Date & initial all entries

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Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- scribe batch # inside of cuff

2-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill all (3) top holes.

3-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145  
Check dimensions between holes on all four sides.

4-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

5-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg 407-667-145. Drill only the top (2) holes.

6-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145

7-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-145. Note: Fwd side has 3x top holes.

8-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D407-667-145.

9-C'sink holes as per Dwg D407-667-145. Allow rivet to sit below surface to compensate for paint.

10 -Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: \_\_\_\_\_ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D206-667-145

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: \_\_\_\_\_

Finish Time: \_\_\_\_\_

PAINT:

Start Time: \_\_\_\_\_

Finish Time: \_\_\_\_\_

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

**Dart Aerospace Ltd**

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate \_\_\_\_\_

16.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate \_\_\_\_\_

17.0

D28911

2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support \_\_\_\_\_

18.0

D3595063395

rubber cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION .63" x 3.95

batch: \_\_\_\_\_

19.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp \_\_\_\_\_

20.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up.

A/R Magnobond 6398 : \_\_\_\_\_

2-Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: \_\_\_\_\_

26.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

4 AN5-30A Bolt

28.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-105

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

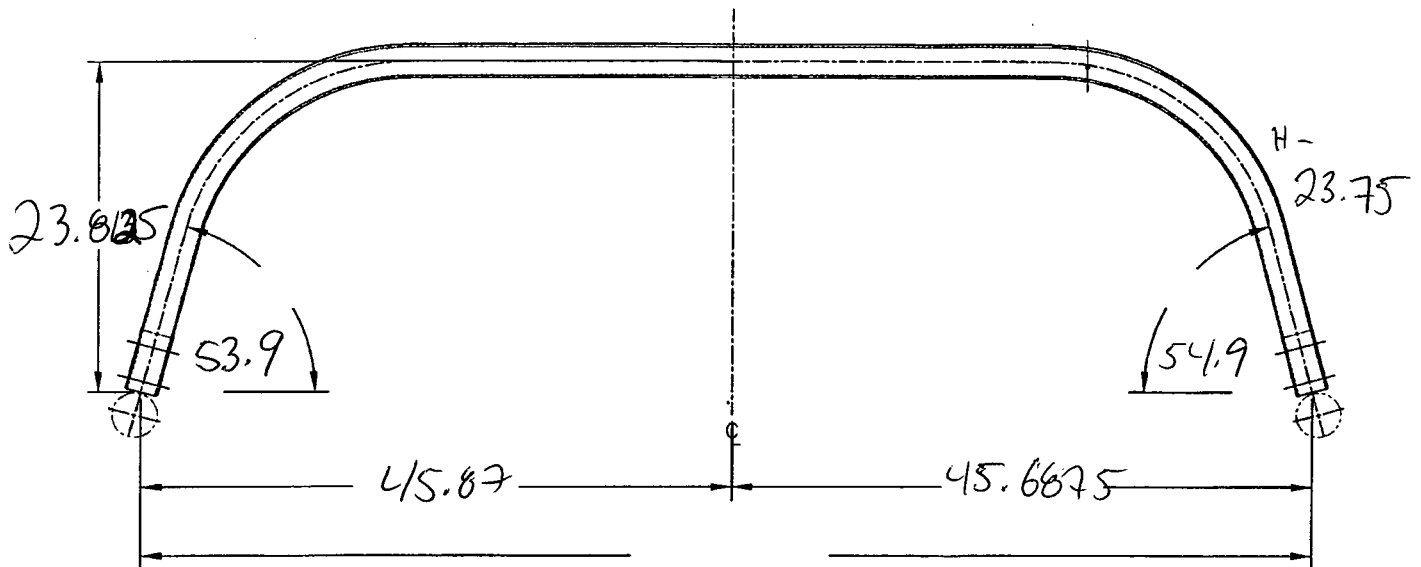
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	46470
<b>Description:</b> Crosstube High Fwd (407)	<b>Part Number:</b>	D407-667-105
<b>Inspection Dwg:</b> D407-667-145	<b>Rev:</b> B	<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.48	23.60
1/2 Span	45.88	46.0
Angle	54	56
Total Span	91.76	92.0



Comments
SCRAP TUBE. 07.03.19

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W 10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115  
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSS TUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED  
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D407-667-145	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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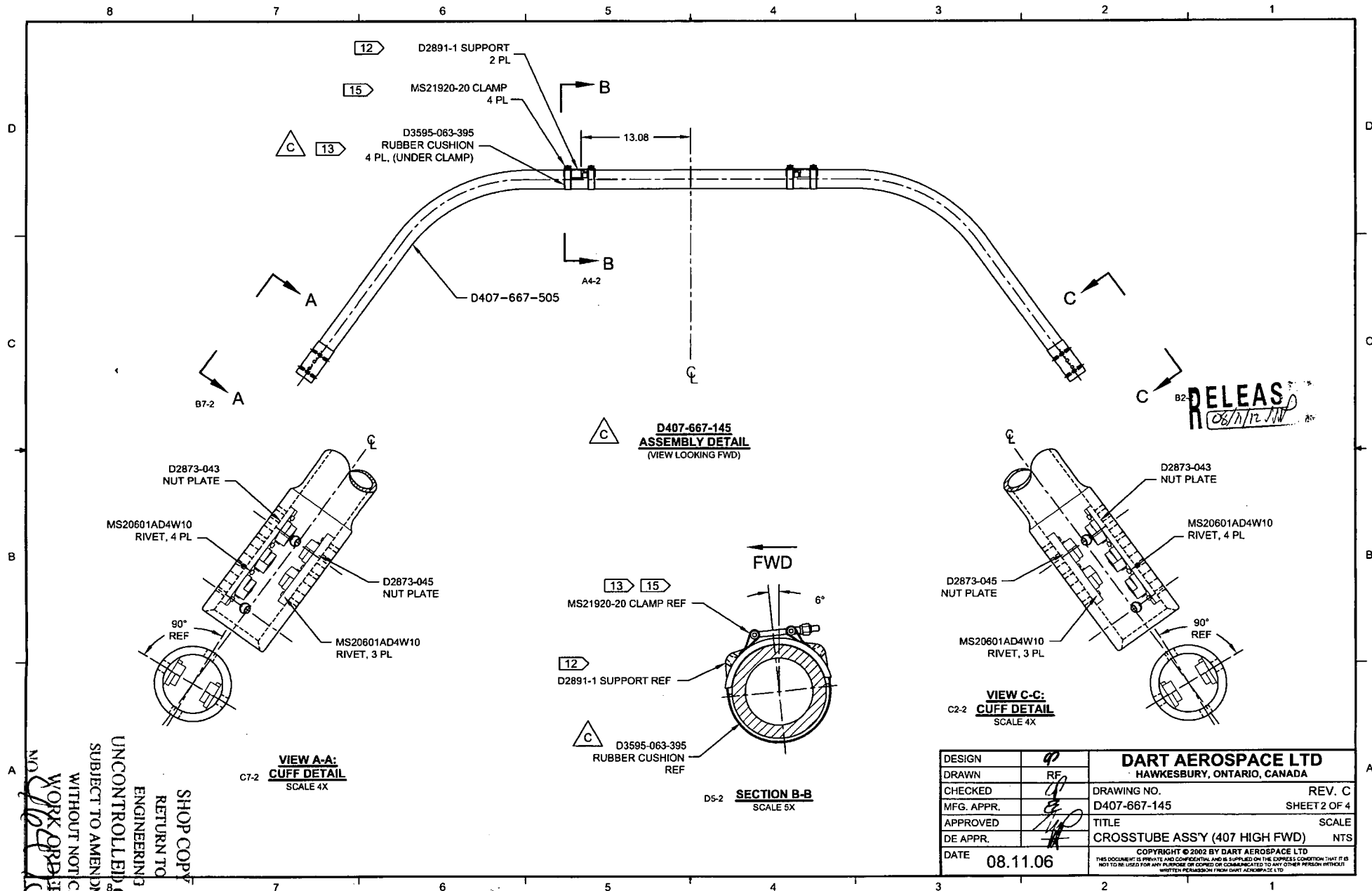
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# Dart Aerospace Ltd

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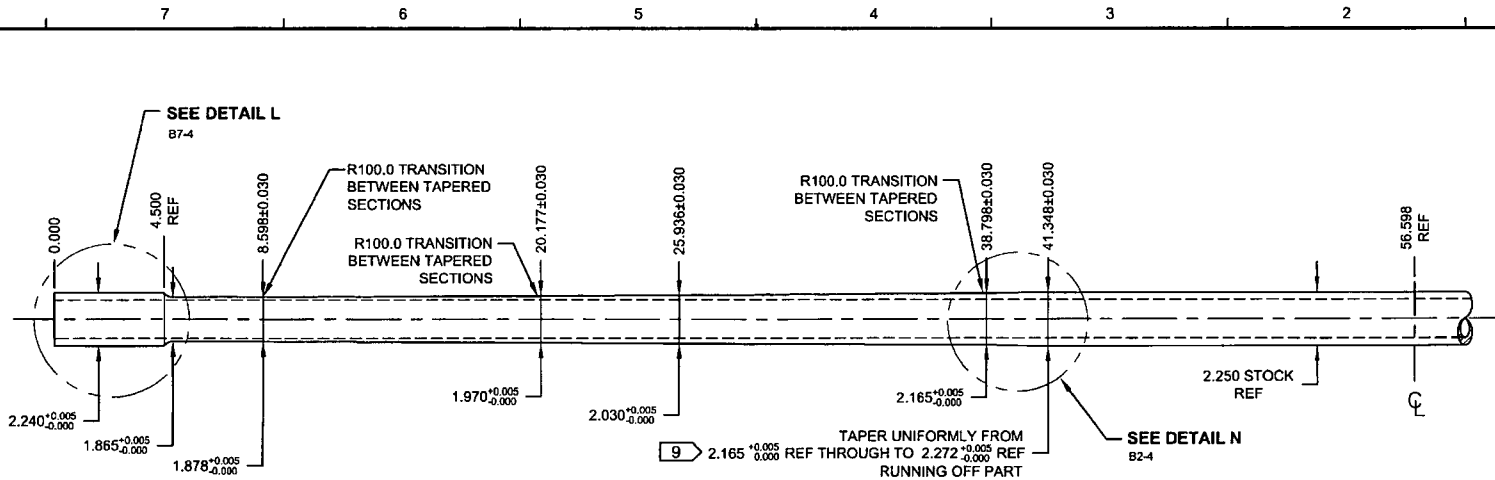
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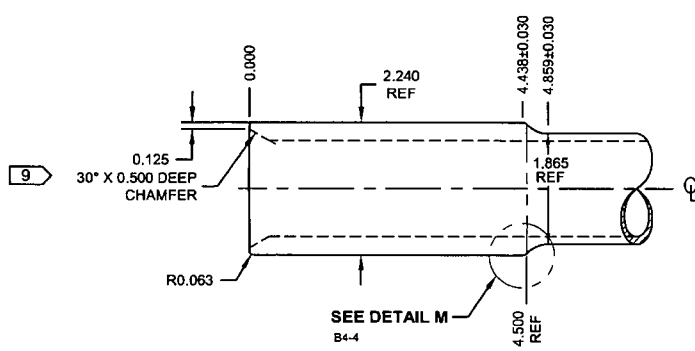
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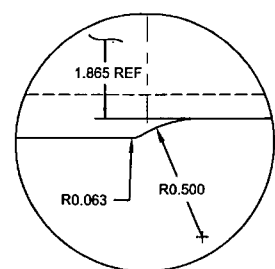
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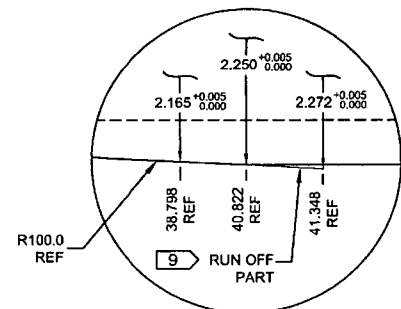
**TURNING DETAIL**



**DETAIL L:  
CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M:  
CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N:  
TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
CS/11/12 MB

DESIGN	9P	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D407-667-145	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (407 HIGH FWD)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries